Work Orde November-30-12				*94	213*						Page 1
Item ID: Revision ID: Item Name:	D3161-9 Hinge 17.0"			Accept	*N900	040	100	)* s	Setup Star	1.7	S1* S2*
Start Date: Required Date: Reference:	11/30/12 12/07/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item l Customer:	D:				··u	( 1/
Approvals:		n: MLJ	Date: 12-12-04			ate:		Ą	Run Star Stop	"IV	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr'	Revi	ision Nbr	<del>.</del> - <del></del>	1							
D3161	Rev	A2									$\Omega a$
*100 *100* Small Fab Small Fab		Small Fab  Memo (1) 72" Hing D3161	ge makes (4) D3161-9 parts	0.00 0.00 at 17" longCut to leng	rth as per Dwg			2x			J3/2
110 *110* QC Quality Control		QC5- Inspect part complete Memo	eteness to step on W/O	0.00 PA 0.00 J3	3 90 3			<u>Q</u>			
120 *120* Packaging Packaging		Identify as per dwg & St  Memo	ock Location: <b>ST</b> ©	0.00							

NCR:	Yes	/ No				WORK ORDER NON-	COI	VFORM	ANCE / UPDA	TE	•		
									,		QA Closed:	Date	
Work Orde	or.					DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Work Orac	-					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	Vo.					Scrap			<b>─</b>	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1		oforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	۷o.		<del></del>			Work Order Update	]		Large Fab C	Composite		Supplier	
Root					Descri	ption of work order update	T	Initial	Action	1	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descript	ion	Date	Verification	QC Inspector
Doc/Data	Ш						1						
Equip/Tooling													
Operator	Ш		1										
Material	Material												
Setup	Щ												
Other .	Ш												
Process													
Supplier													
Training													
Unapproved			L	<u> </u>			<u> </u>						
				_,		<del></del>	AUI	T CATE	GORY				·
Landi	$\overline{}$					General	_	1			1	_	7
	Bending		Bend	_	Grain		<b>—</b>	Ovalized	_	Pressure/Forced			
	Centre Not Concentric to O/S		BOM/Route	_	Hardwa		<u> </u>	Over/Under	<b></b>	Temperature/Cure			
, ·	Cracks		Broken/Damaged	_	1	on Incomplete	<b>⊢</b>	Part Incorre	<del> </del>	Weld			
		Burrs	_	4	ions Incomplete/Unc	<del></del>	Part Lost/M		Wrong Stock Pulled				
	-	Cuffs				Contamination	<u>_</u>	Mainte			Part Moved		•
	Ш	Heat Trea	it			Countersink	L	Mislabe	l∈d		Positioned V	_	<del>-</del> 1
	Ш	Inspection	n Strip in	Tube	<u></u>	Cut Too Short	L	Misread	l		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Order ID 94213 Page 2 November-30-12 10:13:22 AM \*N900040100\* Item ID: D3161-9 Accept Revision ID: Hinge 17.0" Item Name: Start Qty: 2.00 Start Date: 11/30/12 **Cust Item ID:** Required Date: 12/07/12 Req'd Qty: 2.00 **Customer:** Reference: Start Run Process Plan: Tooling: **Approvals:** Date: Date: Stop Date: SPC (Y/N): Date: Qty Reje
Numb

MCD 13-02-21 Tool ID Sequence ID/ Operation Tool # Plan Set Up/ Work Center ID Description Run Hours Code 0.00 130 OC21- Final Inspection - Work Order Release

0.00

Memo

\*120\* OC

**Ouality Control** 

											DQA:	Date:		
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UP	DATE		<del>-</del>		
											QA Closed:	Date:		
Work Ord	er.					DISPOSITION		i	AGAINST DEPARTMENT/PROCESS					
Part No.			Rework Scrap		Machining Small Fab		Crosstube Small Fab	Prod. Eng. Coo		Engineering Quality Other				
NCR No.			Use-as-is Work Order Update		Thermoforming Finishing Large Fab Composite			Rec/Store/Packaging Supplier		Other				
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling	Equip/Tooling													
Operator	Operator													
Material														
Setup														
Other													1	
Process								:						
Supplier	П			ļ										
Training			-				İ	`						
Unapproved														
						F	AUL	T CATE	GORY					
Landi	ing (	Gear				General		_			_		_	
Bending Bend			Bend		Grain			Ovalized		Pressure/Forced				
Centre Not Concentric to O/S		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure					
Cracks		Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld					
Crushed/Crimped Burrs		Burrs		Instruct	ions Incomplete	'Unclear	Part Lost/M	issing	Wrong Stock Pulled					
		Cuffs				Contamination		Mainte	nance		Part Moved		<del>-</del>	
		Heat Trea	at			Countersink		Mislabe	eleid		Positioned	<b>N</b> rong		
		Inspectio	n Strip in	Tube		Cut Too Short	Misread			Power Loss,	/Surge	Other		

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

## **Picklist Print**

November-30-12 10:13:22 AM

Work Order ID:

94213

Parent Item:

D3161-9

Parent Item Name:

Hinge 17.0"

**Start Date:** 11/30/12

Required Date: 12/07/12

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP A04.08.24New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Date Status Issued Issued
MS20257-3-7200		Purchased	No			100	f	25.2057	1.65	عر 3.3	1 2/2 /2
Piano Hinge									c		JUS/02/20
				Location		Loc Qty	<u>Lo</u>	c Code			
				ST209a		25.205684					
				1196	538	0.456					
				1205	521	19.566					
				1215	509	2.21					
				1218	382	2.973684					

M123960 (3.3x)

Page 1

											(	DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Clo	acad:		te:	
		······································												ie.	
Work Orde	er:					DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Part No			Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite		Small Fab Finishing	Prod. Rec/Store/		Water Jet  J. Eng. Coor.  e/Packaging  Supplier		Engineering Quality Other			
Root					Descri	ption of work order update		Initial	Ac	tion	Sign	8	:		
Cause		Date	Step	Qty	or Non-conformance			nief Eng	Desc	ription	Da	te	Verificatio	n	QC Inspector
Doc/Data			]						•	-					
Equip/Tooling															
Operator															
Material	Ш						ļ								
Setup															
Other							Ì				1				
Process									:						
Supplier															
Training															
Unapproved															
						F	AUI	LT CATE	GORY					<u>.</u>	
Landi	ng G	Gear				General		_			_			_	
	Ш	Bending				Bend		Grain			Ovalize	ed			Pressure/Forced
Centre Not Concentric to O/S		BOM/Route	L	Hardwa	re		Over/I	Under	tolerance		Temperature/Cure				
Cracks		Broken/Damaged		Inspecti	on Incomplete		Part In	corre	ct		Weld				
Crushed/Crimped.		Burrs		Instruct	ions Incomplete/	Unclear	Part Lo	ost/M	issing		Wrong Stock Pulled				
Cuffs		Contamination		Mainte	nance		Part M	1oved							
		Heat Trea	at			Countersink		Mislabe	led		Positio	oned \	Wrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power	Loss	/Surge		Other
		Ripples in	Bend			Drill Holes		Offset							

Out of Calibration

Out of Sequence
Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G





DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ON	_ , , ,
CHECKED KF	APPROV <b>I</b> D	DRAWING NO.	REV. A
DATE 02.04.24		TITLE HINGE	SCALE NTS
 - A	02 04 24	VEW YOUE	

	02.04.24	1413
Α	02.04.24	NEW IKUE
ΑI	十十十04.02.27	ADDED D3161-5
A 2	NA 04.06 36	A00 03161-7 & 03161-9

P/N	LENGTH 'L'
D3161-1	13.5"
D3161-3	15.0"
D3161-5	9.9"
P3141-7-	14.0"
The same of I	77.6

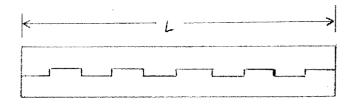
## DESCRIPTION

HINGE (REPLACES MS20257-3-13.5 ON DZ183) HINGE (REPLACES MS 20257-3-150 ON D2950-041)

HINGE

HINGE

HINGE



NOTES:

() MAKE FROM MS20257 - 3-7200 HINGE

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